

Work Order ID 56930

March 15, 2010 9:58:30 AM



Page 1

Item ID: D3589-15

Accept



Setup

Start



Revision ID:

Item Name: LINK

Stop



Start Date: 15/03/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-3-15 Tooling:

Date:

Run

Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100

0.00



Waterjet

FLOW CNC Waterjet

304 .063

Memo

0.00

Cut as per dwg D3589

Prog Rev: B

Dwg Rev: B

Deburr as required

=7 m-p 10/03/15 (20x Octave)

10-3-15

20

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

10-3-15

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56930

March 15, 2010 9:58:30 AM



Page 2

Item ID: D3589-15

Accept

Revision ID:

Item Name: LINK

Start Date: 15/03/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Scolor 1.5

Counter
420

140



Packaging

Packaging

Identify as per dwg & Stock Location: SF WA 0.00

0.00

E 10-3-16 420

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/17 MF

10-3-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 15, 2010 9:58:34 AM

Page 1

Work Order ID: 56930



Parent Item: D3589-15



Parent Item Name: LINK

Comments: IPP Rev:A 08-05-30 new issue DD verified by:ec
02-20 rev.b as per dwg DD verified by:EC

IPP Rev:B 09-

Start Date: 15/03/2010

Required Date: 31/03/2010

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA						100	sf	164.3899	0.0000	2		

304/316 Sheet .063

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	164.3898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	101.3049	

IB 103-5

20

113295

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	50930
Description: Link	Part Number:	D3589-15
Inspection Dwg: D3589	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>10-3-15</u>	Date: <u>10/03/15</u>	Date: N/A

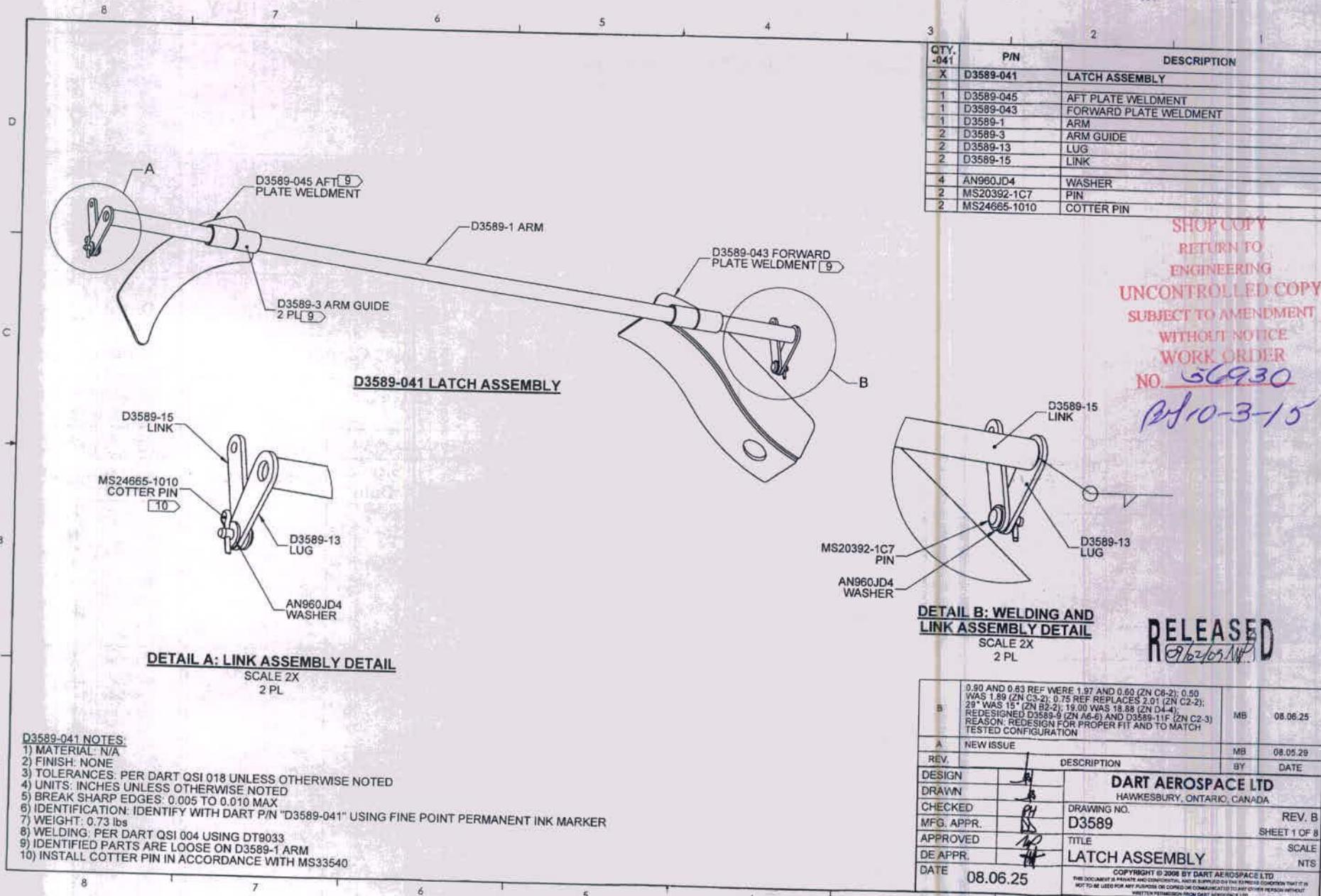
Rev	Date	Change	Revised by	Approved
A	09.05.07	New Issue	KJ/EC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041"
- 7) WEIGHT: 0.73 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
- 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS3354C

RELEASED
07/26/2014

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56930

RELEASED
09/02/03 MHD

LATCH ASSEMBLY NTS
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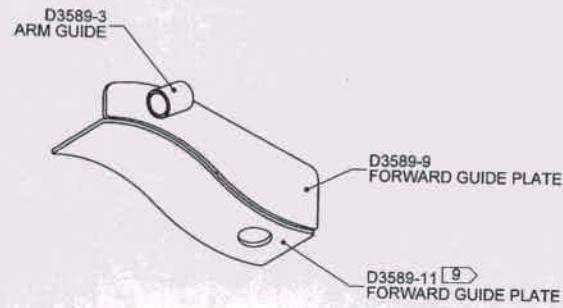
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

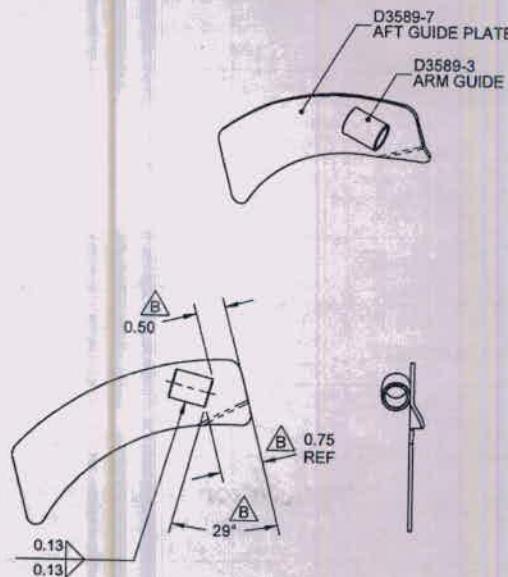
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -043	QTY -045	P/N	DESCRIPTION
X		D3589-043	FORWARD PLATE WELDMENT
	X	D3589-045	AFT PLATE WELDMENT
1	1	D3589-3	ARM GUIDE
1	1	D3589-7	AFT GUIDE PLATE
1		D3589-9	FORWARD GUIDE PLATE
1		D3589-11	FORWARD GUIDE PLATE



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

DESIGN	<i>4</i>	DART AEROSPACE LTD	
DRAWN	<i>4</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>4</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>4</i>	D3589	SHEET 2 OF 8
APPROVED	<i>4</i>	TITLE	SCALE
DE APPR.	<i>4</i>	LATCH ASSEMBLY	NTS
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W/0 50930 RELEASED
09/03/08 M/S

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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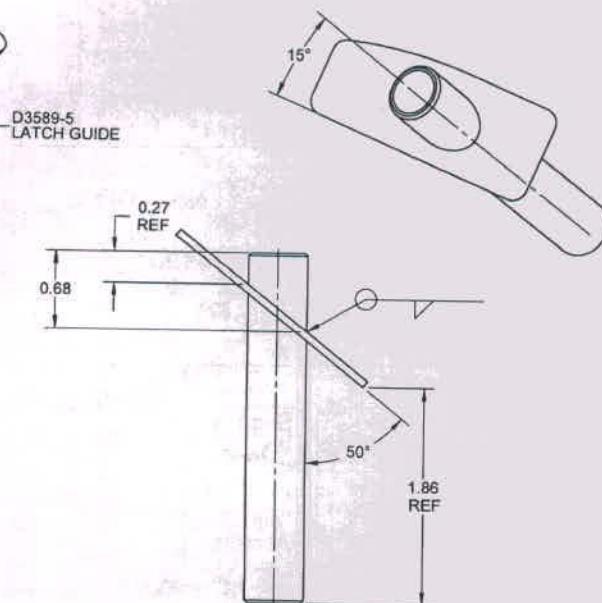
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D

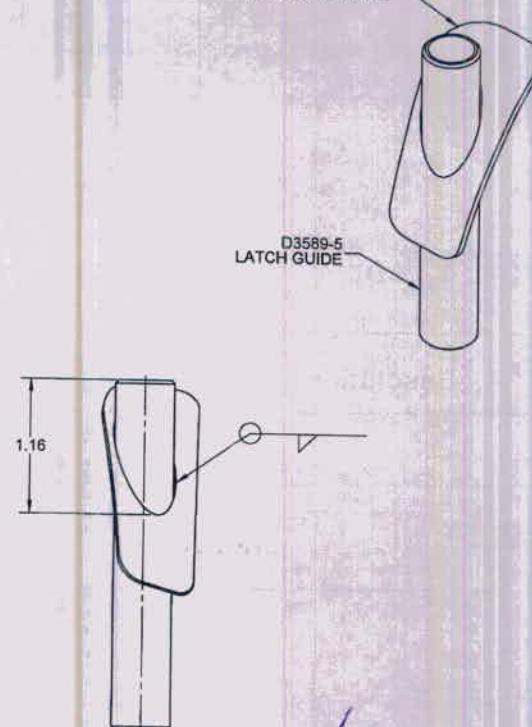
D3589-17
FORWARD GUIDE PLATE



D3589-047 FORWARD GUIDE

QTY	QTY	P/N	DESCRIPTION
-047	-049		
X		D3589-047	FORWARD GUIDE
	X	D3589-049	AFT GUIDE
1	1	D3589-5	LATCH GUIDE
1		D3589-17	FORWARD GUIDE PLATE
	1	D3589-19	AFT GUIDE PLATE

D3589-19
AFT GUIDE PLATE



D3589-049 AFT GUIDE

RELEASED
01/06/10

D3589-047/049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AB</i>	D3589	SHEET 3 OF 8
APPROVED	<i>AB</i>	TITLE	SCALE
DE APPR.	<i>AB</i>	LATCH ASSEMBLY	NTS
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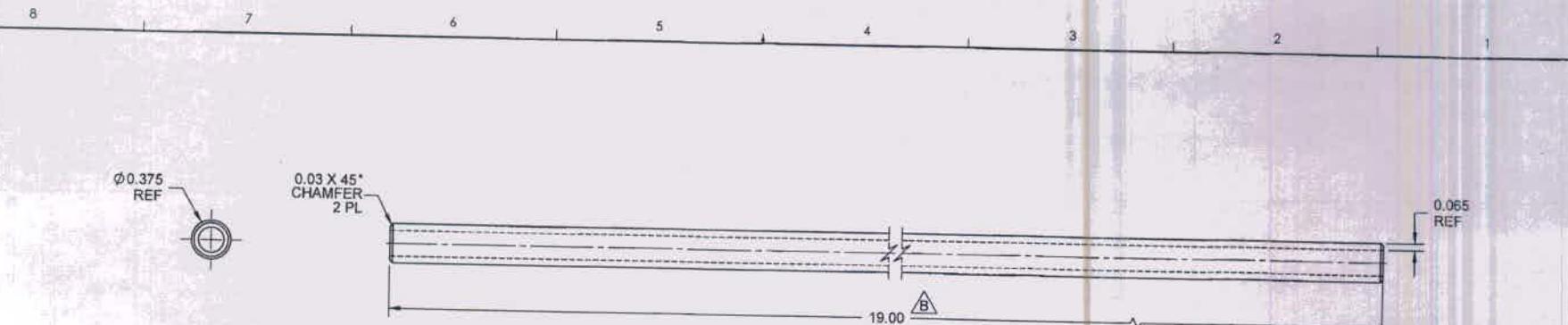
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

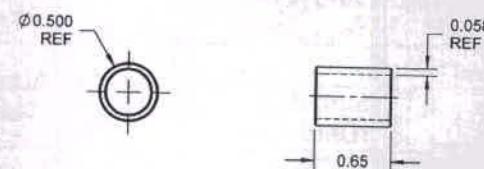
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

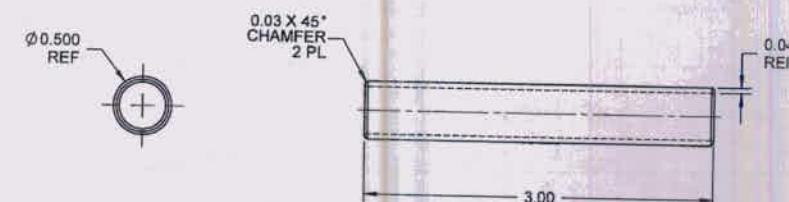
NOTE: Date & initial all entries



D3589-1 ARM



D3589-3 ARM GUIDE



D3589-5 LATCH GUIDE

w/0 36e930

RELEASED
09/02/05 MR

D3589-1/3-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
 - D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
 - D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
 - D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
 - D3589-3 = 0.01 lbs
 - D3589-5 = 0.06 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	
MFG. APPR.	<i>AB</i>	REV. B	
APPROVED	<i>AB</i>	D3589	
DE APPR.	<i>AB</i>	SHEET 4 OF 8	
DATE	08.06.25	TITLE	LATCH ASSEMBLY
		SCALE	NTS

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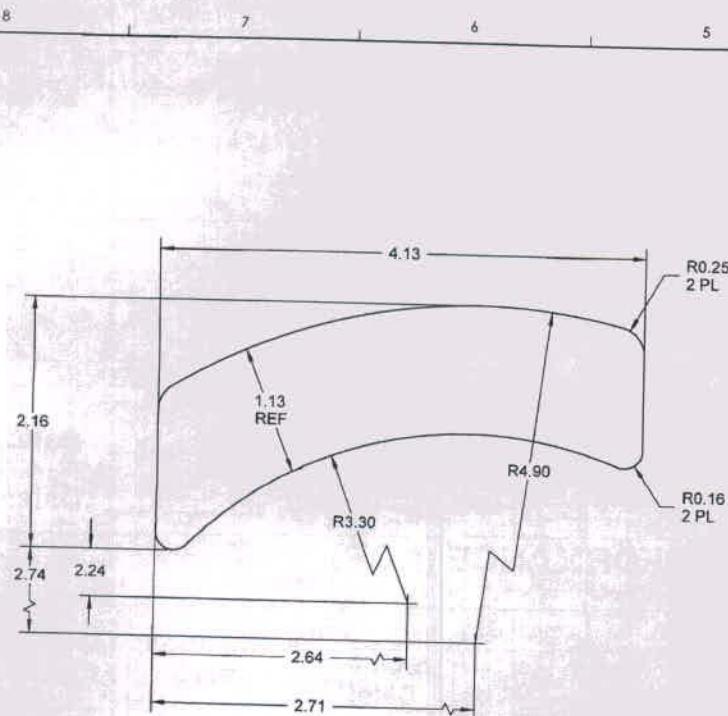
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

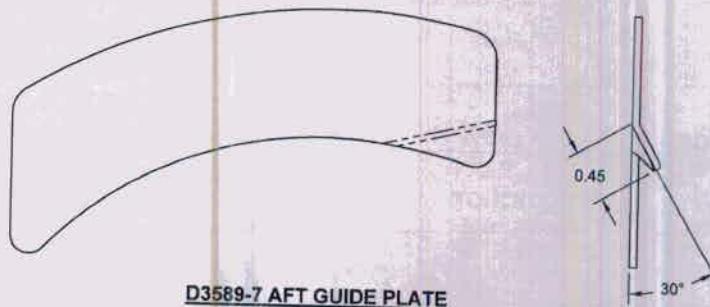
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-7F AFT GUIDE PLATE
FLAT PATTERN



D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F

w/0 56930

RELEASED
09/02/05 MB

D3589-7-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET. PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

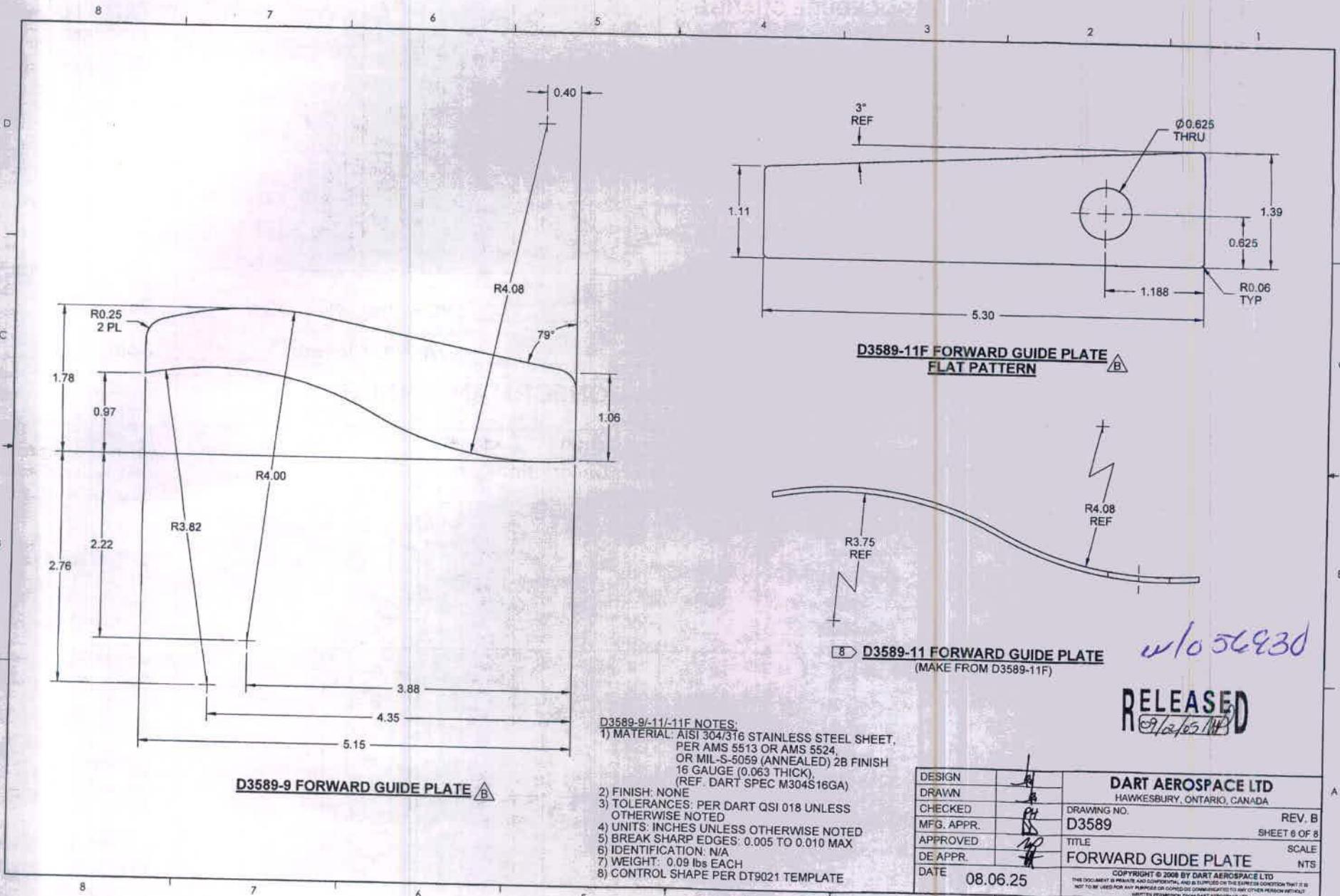
DESIGN	<u>1</u>	DART AEROSPACE LTD	
DRAVN	<u>1</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>1</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>1</u>	D3589	SHEET 5 OF 8
APPROVED	<u>1</u>	TITLE	SCALE
DE APPR.	<u>1</u>	LATCH ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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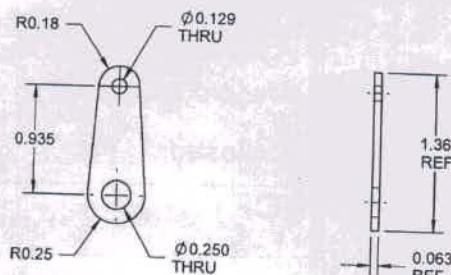


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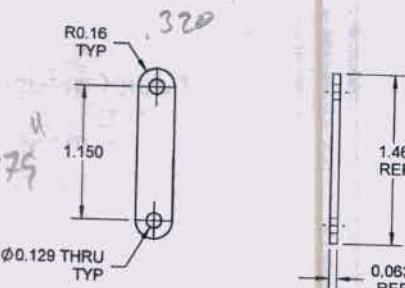
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3589-13 LUG



D3589-15 LINK

w/o 56930

RELEASED
07/02/05 MIA

A D3589-13/15 NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

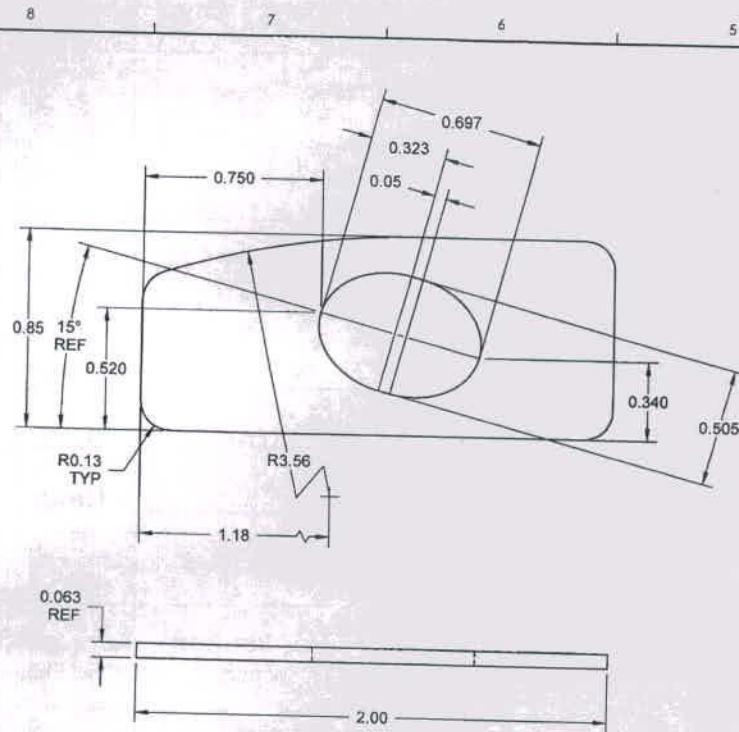
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DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AB</i>	
MFG. APPR.	<i>AB</i>	DRAWING NO.
APPROVED	<i>AB</i>	D3589
DE APPR.	<i>AB</i>	REV. B
		SHEET 7 OF 8
DATE	08.06.25	TITLE
		SCALE
		NTS
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W/O:		WORK ORDER CHANGES					
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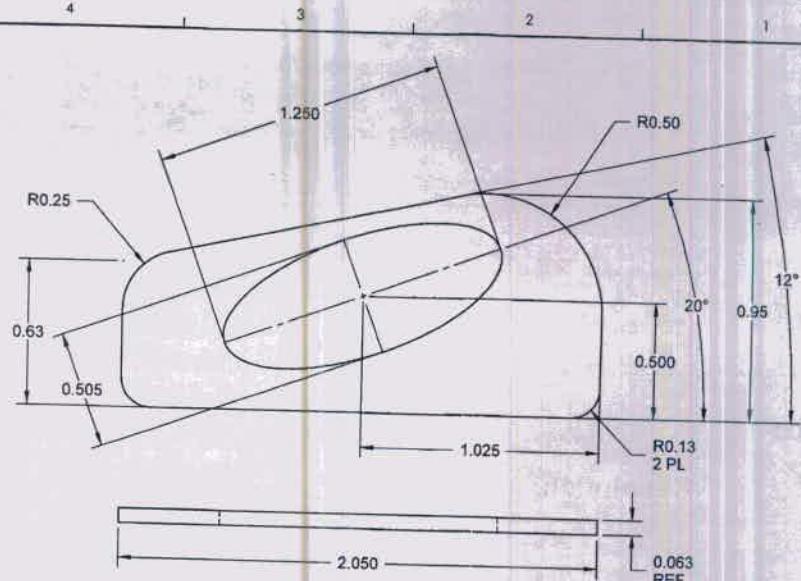
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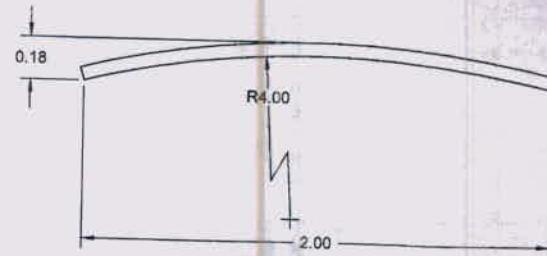
NOTE: Date & initial all entries



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



wl03693d
RELEASED
09/02/05/10

D3589-17/19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH, 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AB</i>	DRAWING NO.	
MFG. APPR.	<i>AB</i>	REV. B	
APPROVED	<i>AB</i>	D3589	SHEET 8 OF 8
DE APPR.	<i>AB</i>	TITLE	SCALE
DATE	08.06.25	LATCH ASSEMBLY	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries